

Work Order ID 69158

Page 1

Tuesday, May 03, 2011 1:36:02 PM

Item ID: D3913-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wide Handle Plate

Start Date: 5/3/2011 Start Qty: 3.00



Cust Item ID:


Required Date: 5/17/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-05-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3913

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304.125

Cut as per dwg D3913

Prog Rev: A

Dwg Rev: A

Deburr as required

B11-5-16

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69158

Tuesday, May 03, 2011 1:36:02 PM



Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: Wide Handle Plate

Start Date: 5/3/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 11/15/16

(4)

140

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD 11-05-19

(4)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/15/19
ME
11-05-19

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 1:36:09 PM

Page 1

Work Order ID: 69158

Parent Item: D3913-15

Parent Item Name: Wide Handle Plate



Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S11GA | | Purchased | No | | | 100 | sf | 161.0000 | 0.1068 | 0.337263 | | | |



304/316 0.125 Sheet



B11-5-16

Location

Loc Qty

Loc Code

MAT020

161

117494

161

117494

(4)

| W/O: | | WORK ORDER CHANGES | | | | | |
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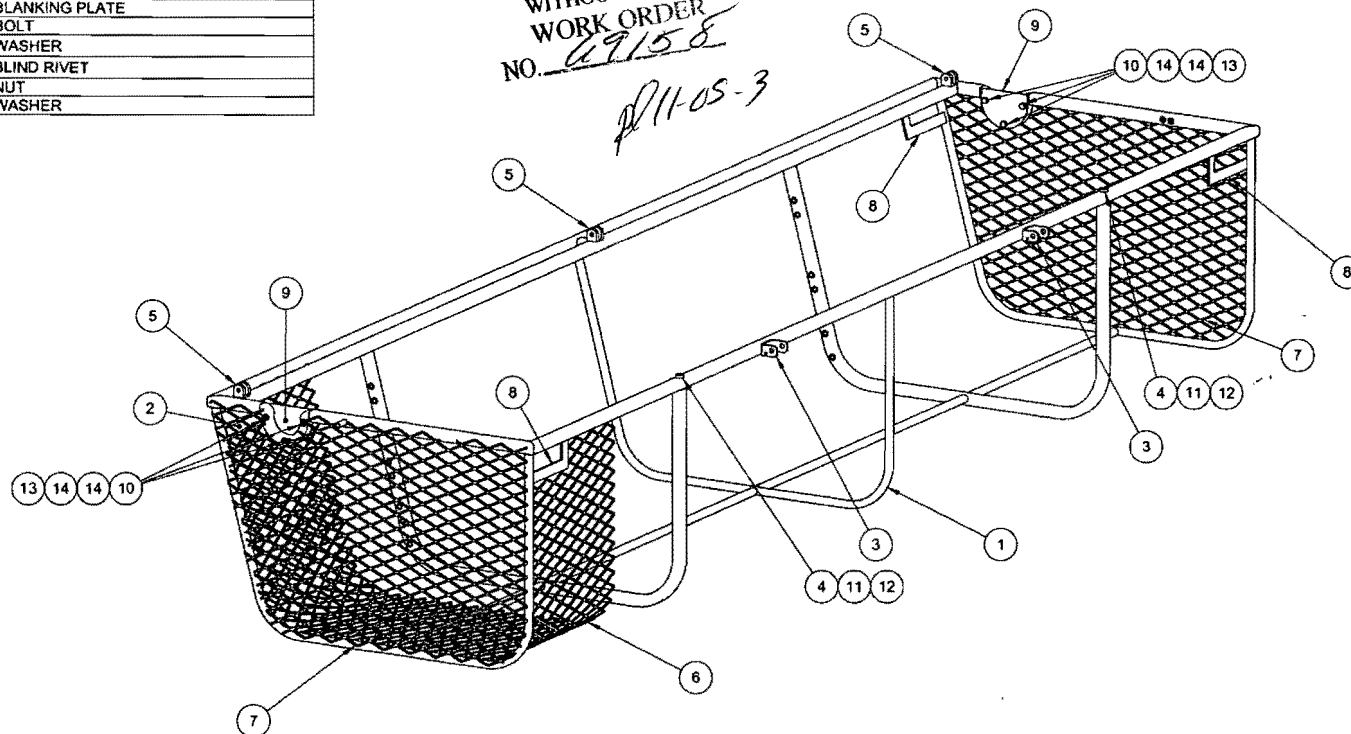
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|---------------------------------|
| | X | D3913-041 | LONG BASKET BASE ASSY (350) |
| 1 | 1 | D3913-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 2 | 1 | D3913-15 | WIDE HANDLE PLATE |
| 3 | 2 | D2581 | MOUNTING BRACKET |
| 4 | 2 | D2931 | BUMPER |
| 5 | 3 | D4016-1 | HINGE HALF, BASE |
| 6 | 1 | D4020-1 | MESH (350 BASKET LONG BASE) |
| 7 | 2 | D4020-11 | END MESH, BASKET |
| 8 | 3 | D4021-1 | HANDLE PLATE |
| 9 | 2 | D4021-5 | BLANKING PLATE |
| 10 | 6 | AN3-10A | BOLT |
| 11 | 2 | AN960JD8 | WASHER |
| 12 | 2 | MS20600AD4W3 | BLIND RIVET |
| 13 | 6 | MS21042L3 | NUT |
| 14 | 12 | NAS1149F0332P | WASHER |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69158
2/11-05-3



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
WJD

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|------------|-------------|---|--------------|
| A | NEW ISSUE | JPH | 10.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3913 | SHEET 1 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY (350) NTS | |
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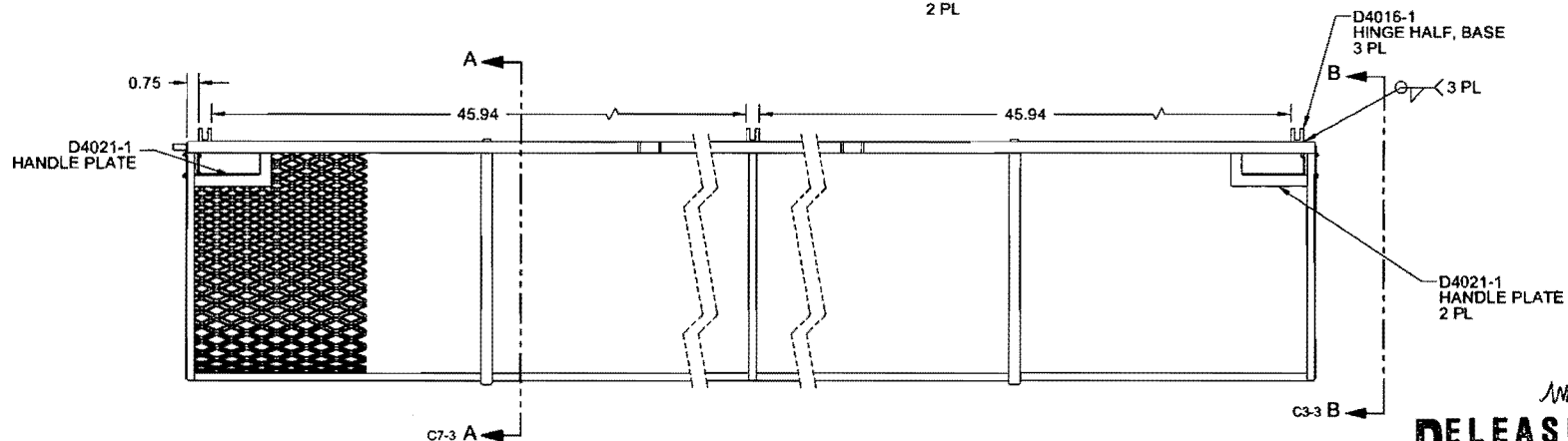
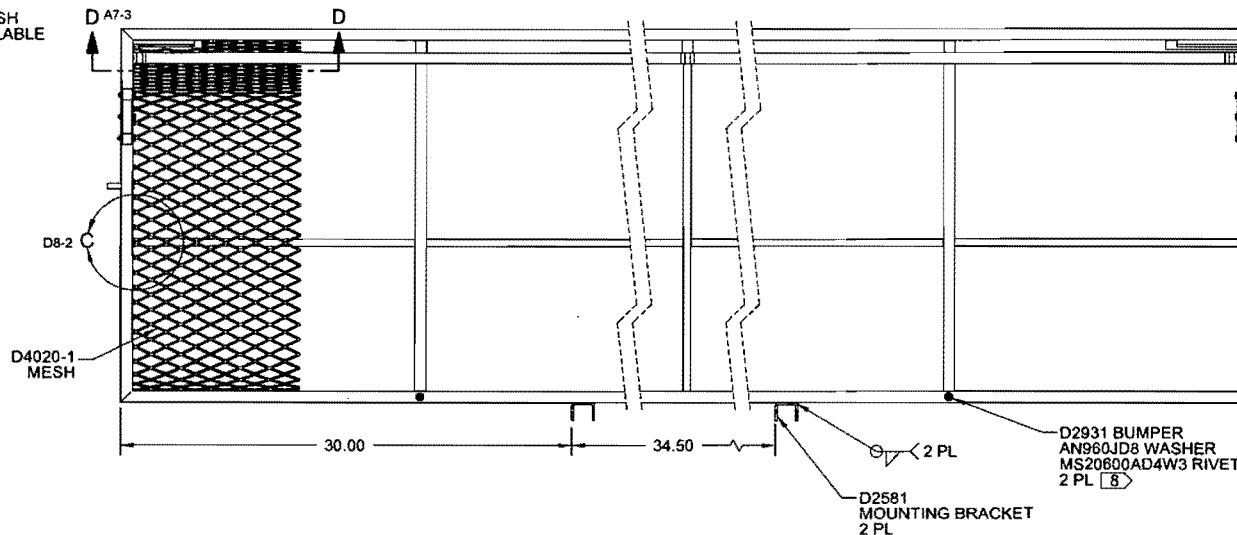
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NOTE: Date & initial all entries

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JRH | HAWKESBURY, ONTARIO, CANADA | |
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| MFG. APPR. | | D3913 | SHEET 2 OF 6 |
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WLO 69158

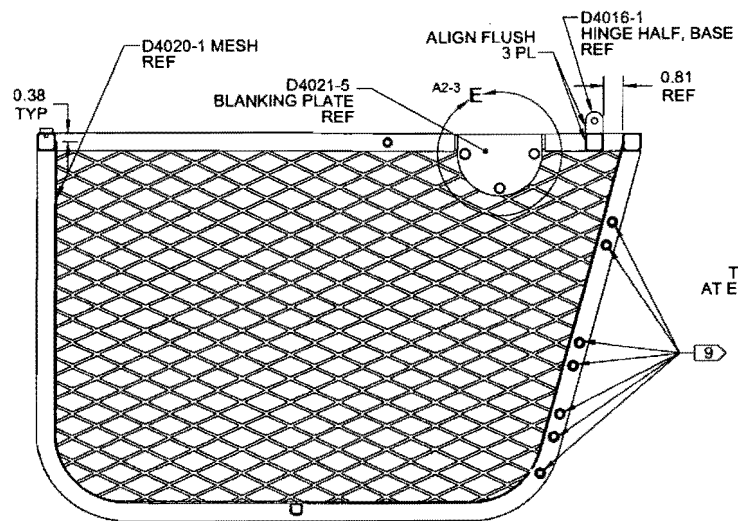
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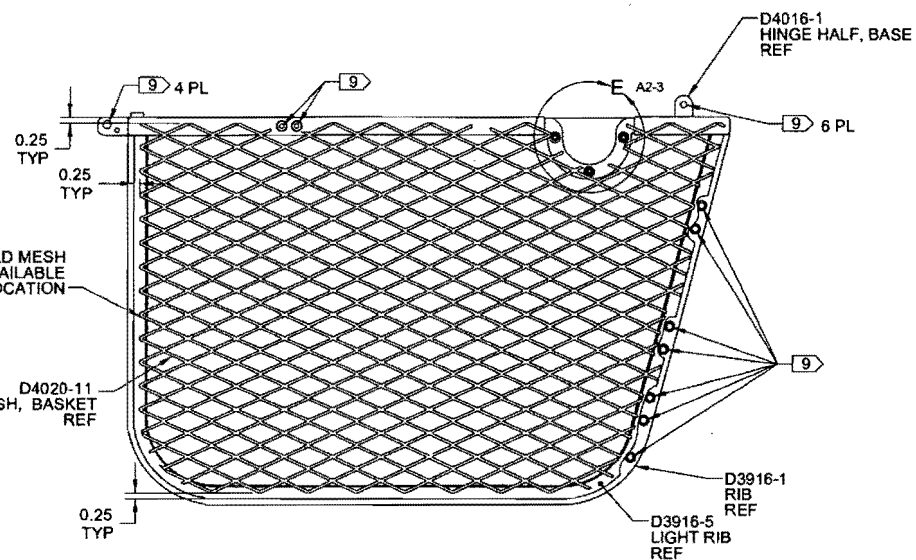
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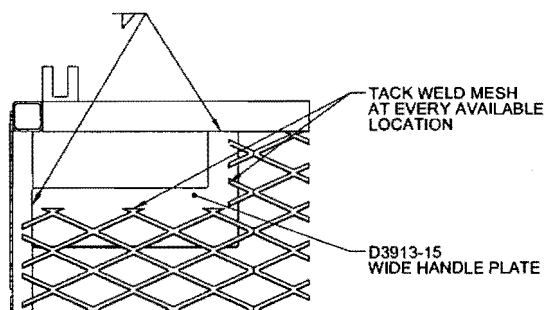
NOTE: Date & initial all entries



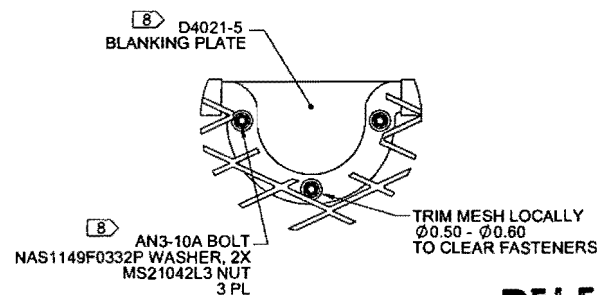
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

also call 58

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2010-03-22

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|---|----------------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JFH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JFH | DRAWING NO. | REV. A |
| MFG. APPR. | JFH | D3913 | SHEET 3 OF 6 |
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| DE APPR. | JFH | LONG BASKET BASE ASSY (350) NTS | |
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NOTE: Date & initial all entries

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u/o A/58

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DATE 10.03.16

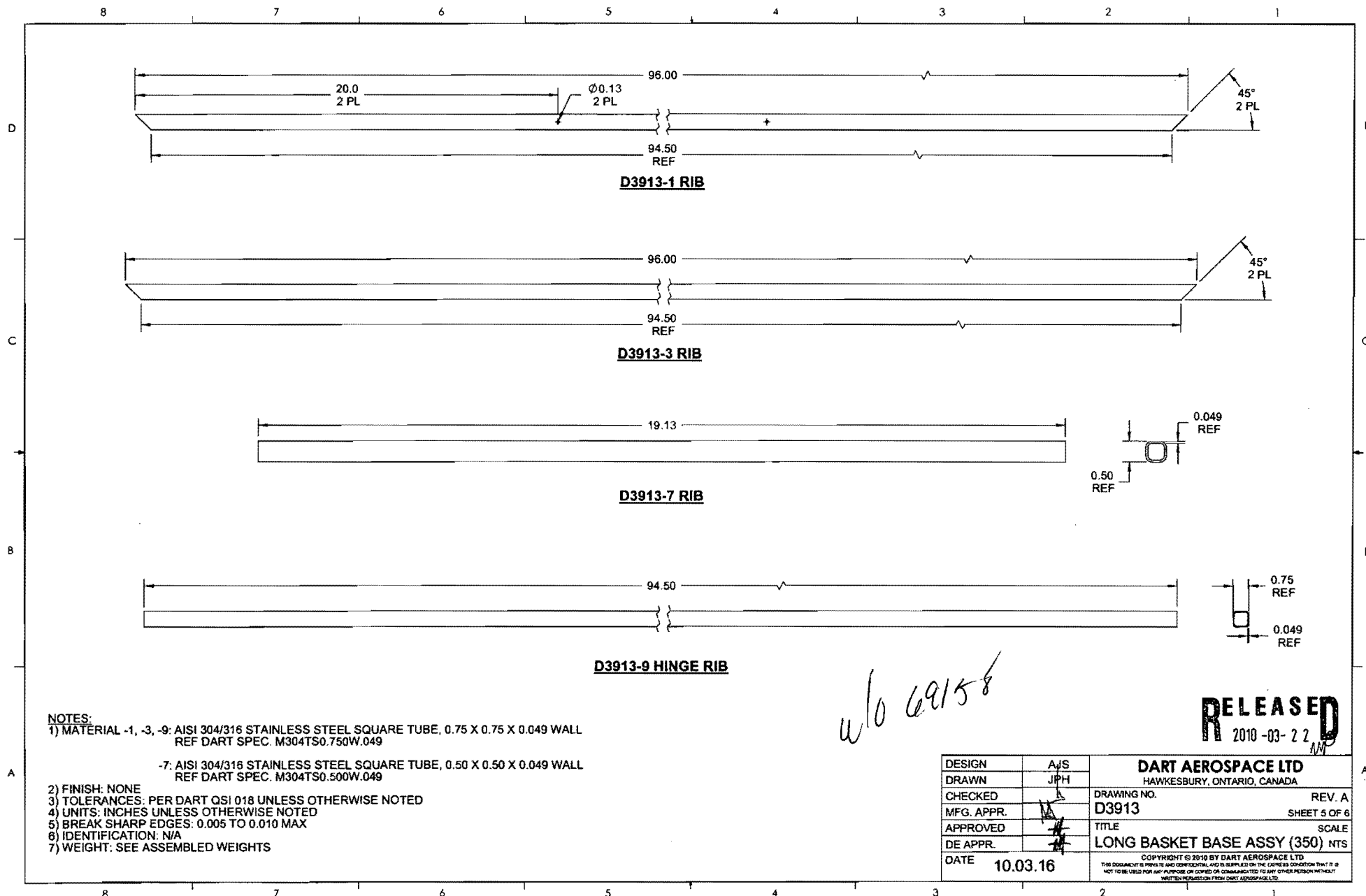
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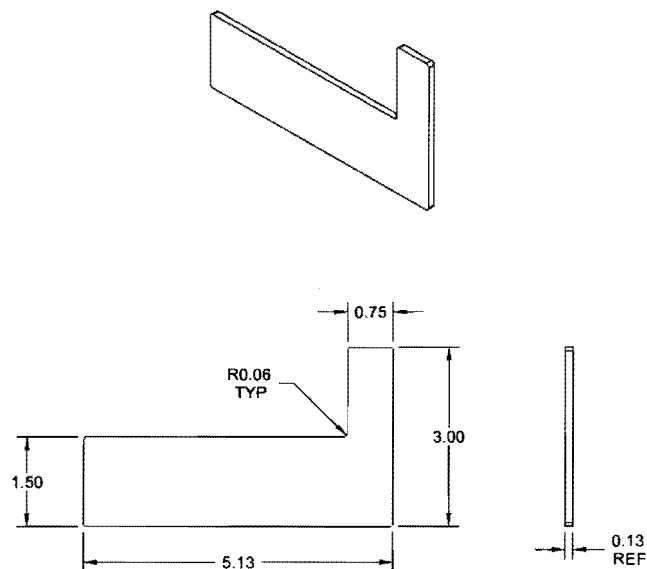
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



NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

| | | | |
|---|---|--|--------------|
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| DRAWN | JFH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. A |
| MFG. APPR. |  | D3913 | SHEET 6 OF 6 |
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[Signature]

w/0 69158

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